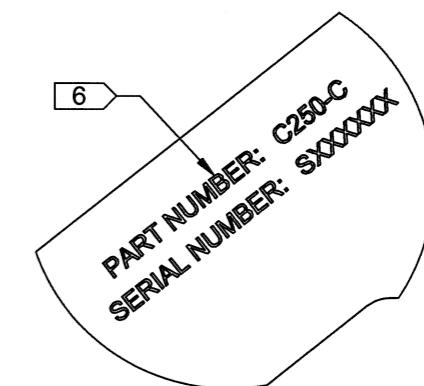
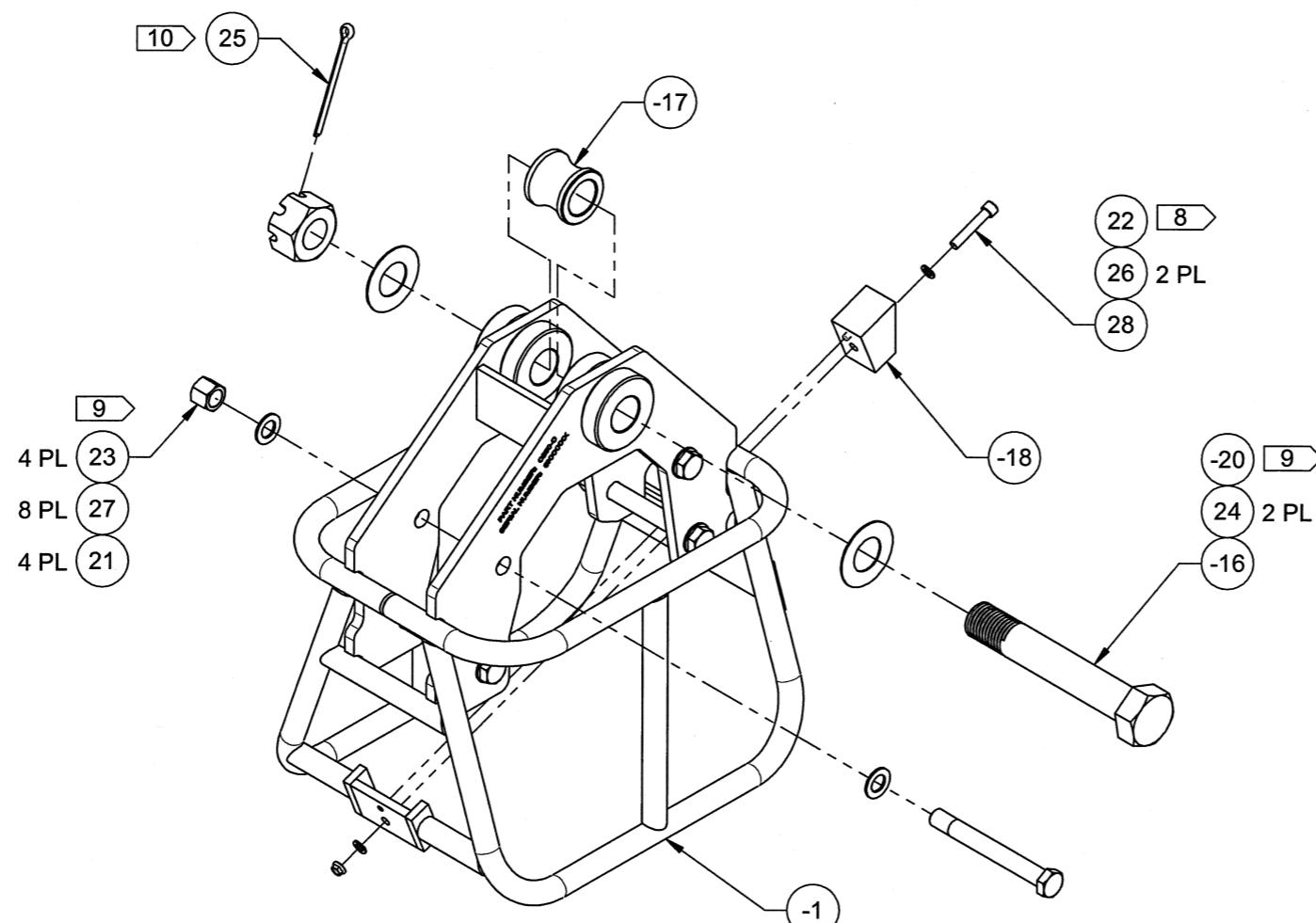
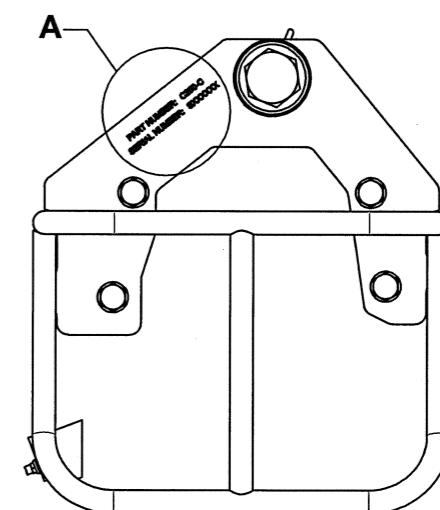


C250-C C250 CAGE ASSEMBLY

D	<p>ITEM -20 LIFTING NUT WAS ITEM 27 MS35692-106 -1 FINISH WAS POWDERCOAT RED IS PRIME AND PAINT RED. MOVED T/N AND S/N IDENTIFICATION TO TOP LEVEL ASSEMBLY. DIM WAS 2.190 IS 2.19 REF. DIM WAS 4.10 IS 4.10 REF -5, -6, -11, -12, -13, -14, -15 REMOVED STOCK VIEW -16 DIM WAS $\phi 1.500$ IS $\phi 1.500-1.495$. DIM WAS 0.867 IS 0.623. DIM WAS 3.50 REF IS 2.06 REF. DIM WAS 5.50-4.67 IS 6.96. DIM WAS 9.00 IS 9.01 -17 DIM WAS $\phi 2.75$ IS $\phi 2.375$. DIM WAS 1.75 IS 1.63. DIM WAS $\phi 2.183-2.180$ IS $\phi 2.173-2.170$</p>	19-891	KPT																																													
C	<p>SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE C250-C-1 SUPERCEDES C250-1100 C250-C-2 SUPERCEDES C250-1100-1 C250-C-3 SUPERCEDES C250-1100-3 C250-C-4 SUPERCEDES C250-1100-5 C250-C-7 SUPERCEDES C250-1100-11 C250-C-8 SUPERCEDES C250-1100-13 C250-C-9 SUPERCEDES C250-1100-15 C250-C-10 SUPERCEDES C250-1100-17 C250-C-11 SUPERCEDES C250-1100-19 C250-C-12 SUPERCEDES C250-1100-21 C250-C-13 SUPERCEDES C250-1100-23 C250-C-14 SUPERCEDES C250-1100-25 C250-C-15 SUPERCEDES C250-1100-27 C250-C-16 SUPERCEDES PC250-1120 C250-C-18 SUPERCEDES PC250-1100-9 ITEM 22 AN12-61A WAS PC250-1110 ITEM 23 MS21042-6 WAS C10-35 ITEM 24 MS21044N12 WAS PC250-1150 ITEM 25 MS21299-24 WAS PC250-1130 ITEM 26 MS24665-690 WAS PC250-1170 ITEM 27 MS35692-106 WAS PC250-1160 ITEM 28 NAS1149F0663P WAS C10-36 ITEM 29 NAS1149F1290P WAS PC250-1140 REMOVED C250-1100-7 ADDED C250-C-5, C250-C-6, C250-C-17, C250-C-22, ITEM 30 NAS1351-6-32P, AND ITEM 31 MS16555-646 -1 REVISED WELDING SYMBOLS -3 DIM WAS $\phi .438$ IS $\phi 0.397$. DIM WAS $\phi .250$ IS $\phi 0.257$ -7 ADDED STEP TO FIT INTO ITEM -9 LIFTING PLATE. DIM WAS $\phi 1.520$ IS $\phi 1.531$. DIM WAS $2X .04 X 45^\circ$ IS $0.04 X 45.0^\circ$ CMF 3 PL. REMOVED .955 DIM -8 DIM WAS $(2X 71^\circ)$ IS 71.0° 2 PL. REMOVED 7.90 DIM -9 DIM WAS $\phi 1.520$ IS $\phi 2.000$. DIM WAS $\phi .780$ IS $\phi 0.781$. DIM WAS $R.06$ IS $R0.06$ 4 PL. ADDED $50.7^\circ, 38.4^\circ, 81.8^\circ, 18.0^\circ, 26.1^\circ, 3.19, 3.32,$ 2.06, AND 3.92 DIMS -11, -12, -13, -14, -15 ADDED LOCATIONS FOR $\phi 1.000$ THRU HOLES -16 LIFTING BOLT WAS MANUFACTURED USING MCMASTER-CARR#91268A967 IS MANUFACTURED AS PER ASTM A354 (GRADE BD). DIMENSIONS AS PER ASME B18.2.1. DIM WAS 9.25 IS 9.00. DIM WAS $7.25 \pm .030$ IS $5.54-4.67$. DIM WAS $\phi .297$ IS $\phi 0.312$. ADDED 0.867 DIM. REMOVED 8.65 DIM -19 BUMPER WAS MANUFACTURED USING E3TZ-4730-A IS MANUFACTURED USING UHMW</p>	19-821	KPT																																													
A	<table border="1"> <thead> <tr> <th>REV.</th> <th colspan="2">DESCRIPTION</th> <th>ECN #</th> <th>BY</th> </tr> </thead> <tbody> <tr> <td></td> <td>DESIGN</td> <td>KPT</td> <td colspan="2" style="text-align: center;">DART AEROSPACE LTD</td> </tr> <tr> <td></td> <td>DRAWN</td> <td>KPT</td> <td colspan="2" style="text-align: center;">HAWKESBURY, ONTARIO, CANADA</td> </tr> <tr> <td></td> <td>CHECKED</td> <td>ZF</td> <td colspan="2" style="text-align: center;">REV. D</td> </tr> <tr> <td></td> <td>MFG. APPR.</td> <td>DP</td> <td colspan="2" style="text-align: center;">SHEET 1 OF 23</td> </tr> <tr> <td></td> <td>APPROVED</td> <td>XIP</td> <td colspan="2"></td> </tr> <tr> <td></td> <td colspan="2">TITLE C250 CAGE ASSEMBLY</td> <td>SCALE</td> <td>NTS</td> </tr> <tr> <td></td> <td colspan="2"></td> <td>[Icon]</td> <td></td> </tr> <tr> <td></td> <td colspan="2">DATE 2019-10-21</td> <td colspan="2">COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</td> </tr> </tbody> </table>	REV.	DESCRIPTION		ECN #	BY		DESIGN	KPT	DART AEROSPACE LTD			DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA			CHECKED	ZF	REV. D			MFG. APPR.	DP	SHEET 1 OF 23			APPROVED	XIP				TITLE C250 CAGE ASSEMBLY		SCALE	NTS				[Icon]			DATE 2019-10-21		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			A
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ITEM #	QTY	PART #	PART TITLE
-1	1	C250-C-1	C250 CAGE WELDMENT
-16	1	C250-C-16	LIFTING BOLT
-17	1	C250-C-17	LIFTING BUSHING
-18	1	C250-C-18	BUMPER ASSEMBLY
-20	1	C250-C-20	LIFTING NUT
21	4	AN12-61A	CAD. PLATED STEEL HEX BOLT 3/4"-16 X 5-3/16" GRIP LG. X 6-13/32" LG.
22	1	MS21042-6	CAD. PLATED STEEL SELF-LOCKING NUT 3/8"-24 X 0.275" HT.
23	4	MS21044N12	CAD PLATED STEEL SELF-LOCKING HEX NUT 3/4"-16 X 0.873" HT.
24	2	MS21299-24	CAD. PLATED STEEL WASHER 1.504" ID. X 2.879" OD. X 0.062" THK.
25	1	MS24665-690	CAD. PLATED STEEL COTTER PIN 5/16" DIA. X 4" LG.
26	2	NAS1149F0663P	CAD. PLATED STEEL WASHER 0.390" ID. X 0.625" OD. X 0.063" THK.
27	8	NAS1149F1290P	CAD PLATED STEEL WASHER 0.765" ID. X 1.312" OD. X 0.090" THK.
28	1	NAS1351-6-32P	CAD. PLATED STEEL SOCKET HEAD CAP SCREW 3/8"-24 X 2" LG.



DETAIL A

NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: X-TENSION STAMP T/N AND S/N, AS SHOWN, PER QSI 044 SECTION 6.2

7) ASSEMBLE AS SHOWN

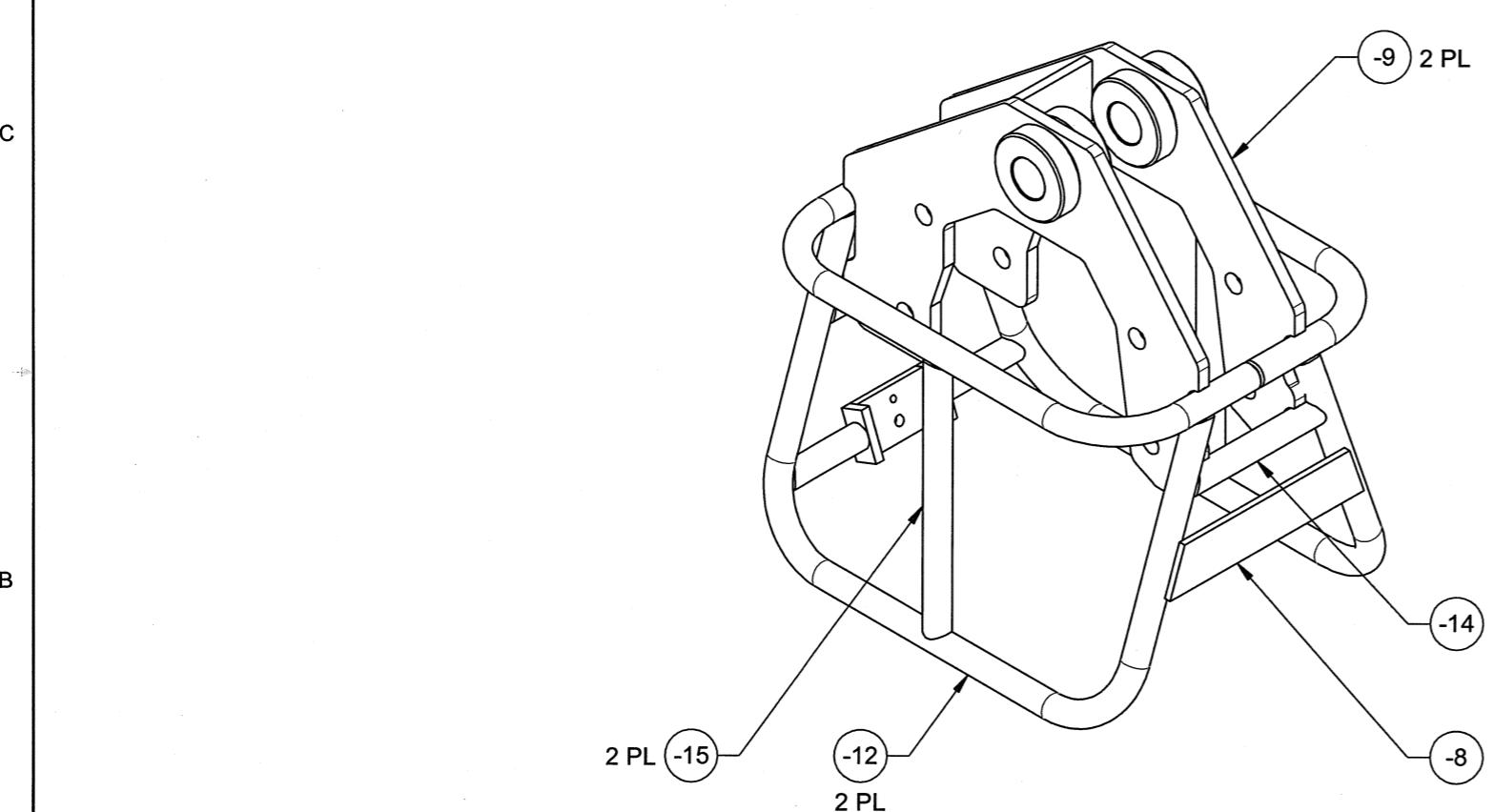
8) TORQUE ITEM 22 TO 13-16 FT-LBS (160-190 IN-LBS)

9) INSTALL ITEMS -20 AND 23 HAND TIGHT

10) DO NOT FOLD ITEM 25

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	
MFG. APPR.	DP	
APPROVED	<i>[Signature]</i>	REV. D
DATE 2019-10-21		SHEET 2 OF 23
TOOL PART # C250-C		SCALE NTS
TITLE C250 CAGE ASSEMBLY		
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ITEM #	QTY	PART #	PART TITLE
-2	1	C250-C-2	BUMPER BRACKET WELDMENT
-5	1	C250-C-5	LEFT HAND BUMPER TUBE
-6	1	C250-C-6	RIGHT HAND BUMPER TUBE
-7	4	C250-C-7	CAGE BOSS
-8	1	C250-C-8	FRONT PLATE
-9	2	C250-C-9	LIFTING PLATE
-10	1	C250-C-10	LIMITING PLATE
-11	1	C250-C-11	MID TUBE
-12	2	C250-C-12	SIDE HOOP
-13	2	C250-C-13	TOP RING
-14	1	C250-C-14	TOP TUBE
-15	2	C250-C-15	SIDE TUBE

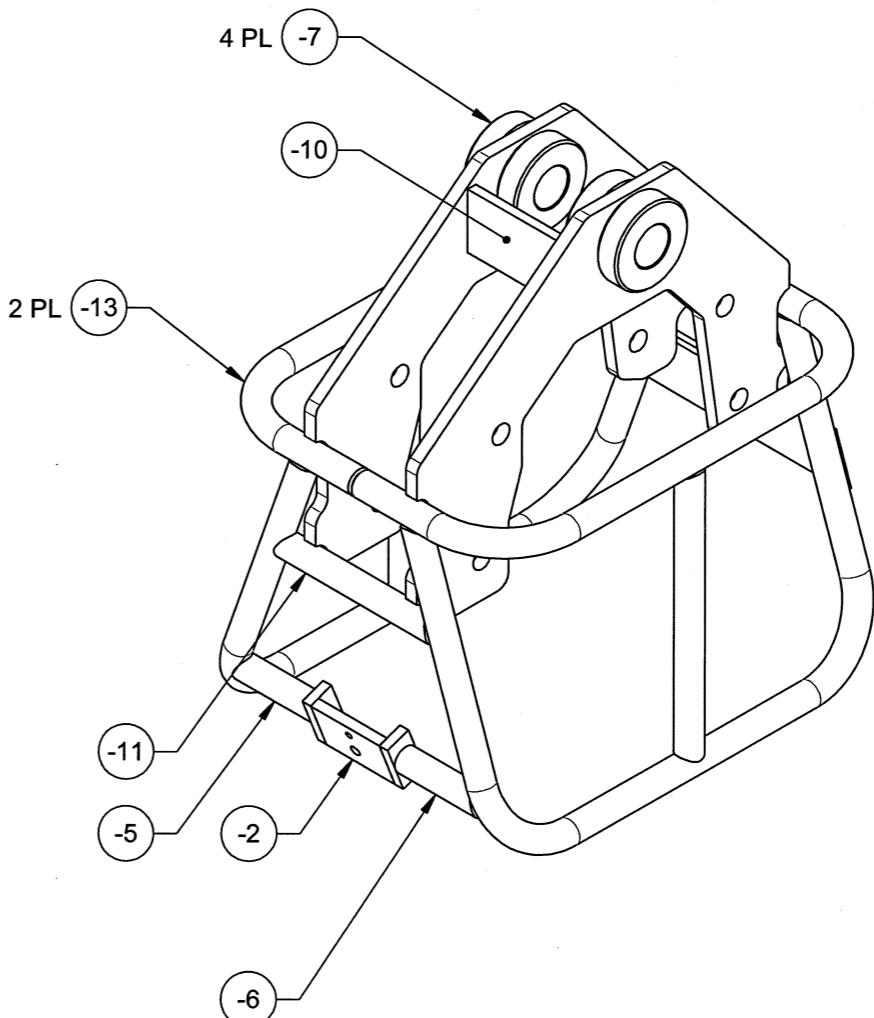


C250-C-1 C250 CAGE WELDMENT

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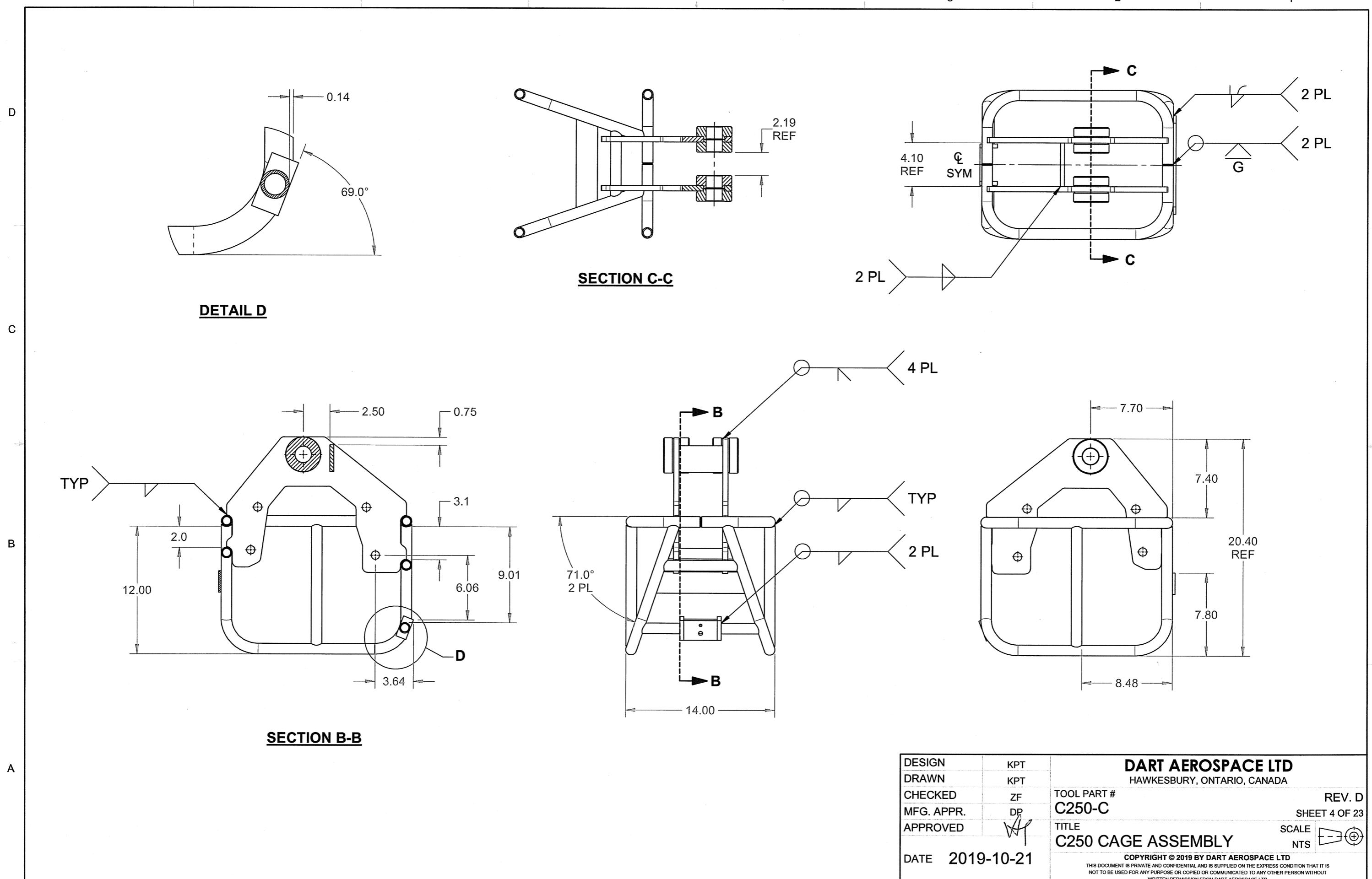
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: PRIME AND PAINT RED AS PER QSI 005 SECTION 4.2.2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS
- 9) NOTCH ENDS OF ITEMS -5, -6, -11, -12, -14, AND -15 AS REQUIRED, PRIOR TO WELDING



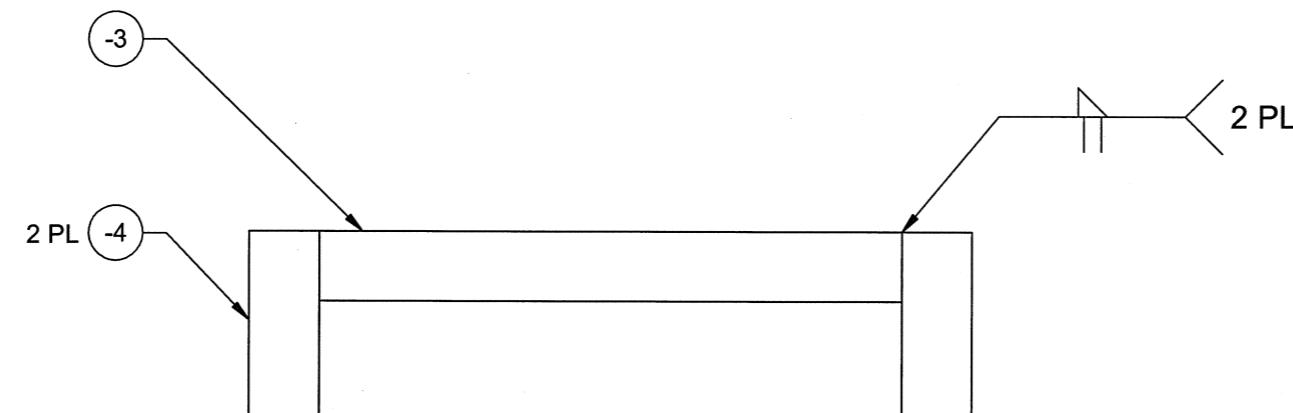
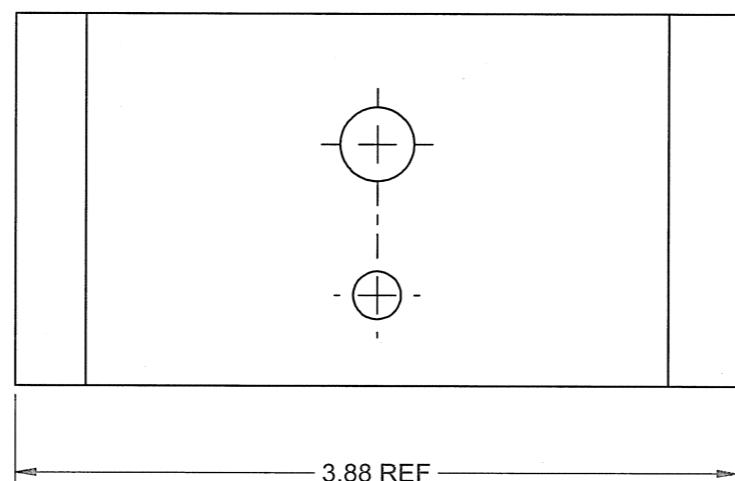
DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	ZF	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	C250-C
APPROVED	<i>[Signature]</i>	TITLE	C250 CAGE ASSEMBLY
DATE 2019-10-21		REV. D	SHEET 3 OF 23
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ITEM #	QTY	PART #	PART TITLE
-3	1	C250-C-3	FRONT PLATE BUMPER BRACKET
-4	2	C250-C-4	SIDE PLATE BUMPER BRACKET



C250-C-2 BUMPER BRACKET WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	TOOL PART # C250-C
MFG. APPR.	DP	REV. D
APPROVED	VJ	SHEET 5 OF 23
TITLE C250 CAGE ASSEMBLY		
DATE 2019-10-21		
SCALE NTS		

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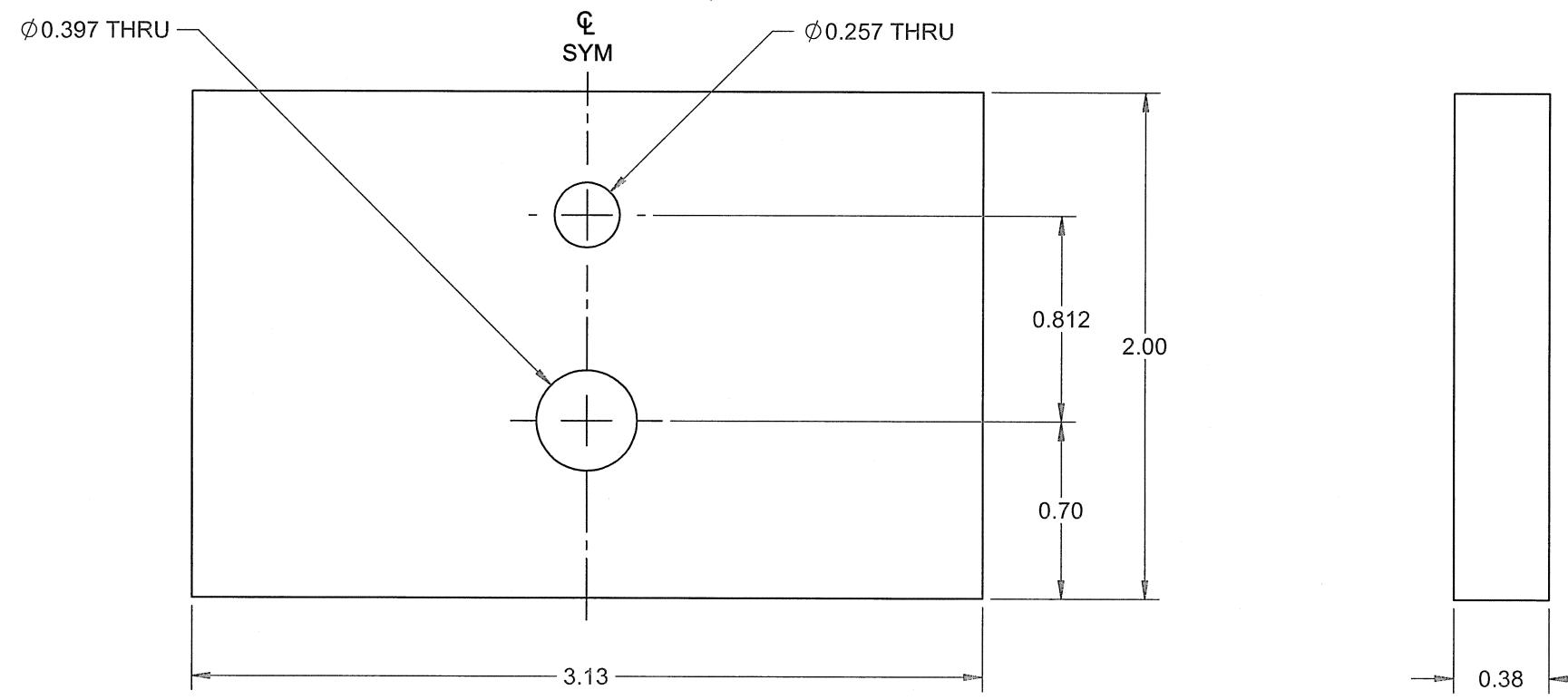
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C250-C-3 FRONT PLATE BUMPER BRACKET

NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	TOOL PART #	REV. D SHEET 6 OF 23
MFG. APPR.	DP	C250-C	
APPROVED	(Signature)	TITLE	
DATE 2019-10-21		SCALE	NTS

C250 CAGE ASSEMBLY

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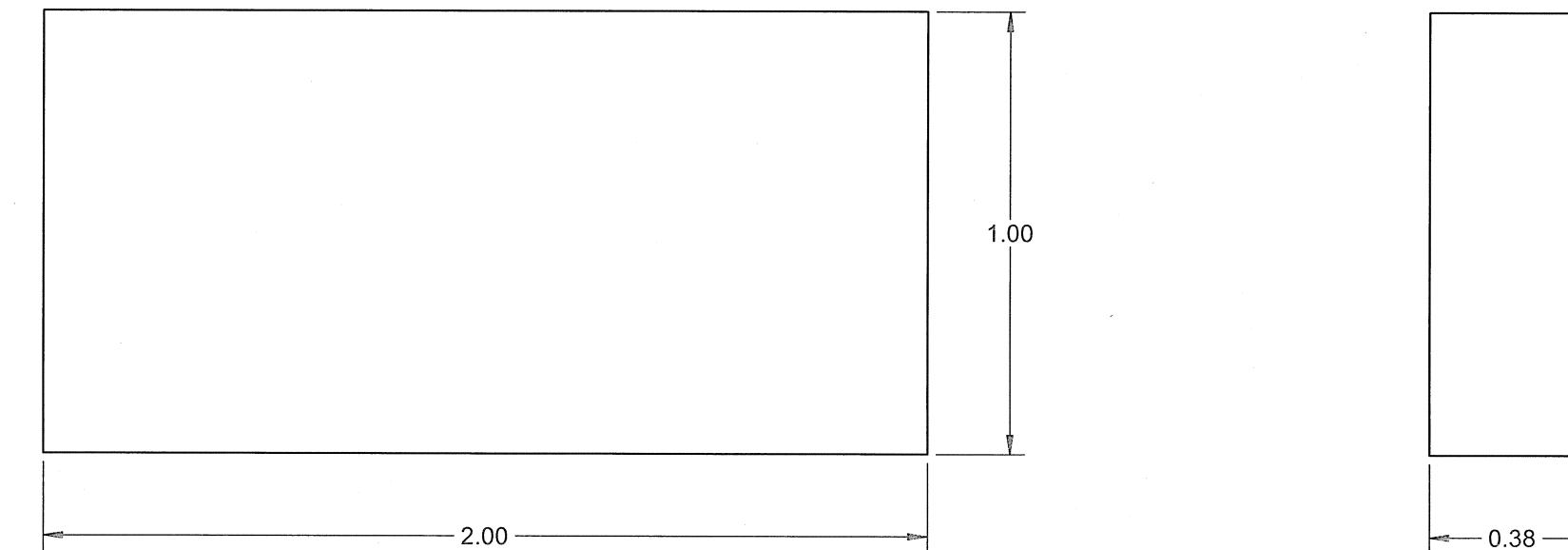
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C250-C-4 SIDE PLATE BUMPER BRACKET

NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	ZF	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	REV. D	SHEET 7 OF 23
APPROVED	<i>[Signature]</i>	TITLE C250 CAGE ASSEMBLY	
DATE 2019-10-21		SCALE NTS	

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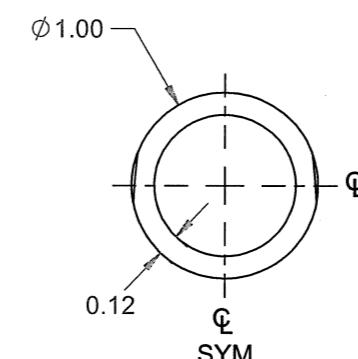
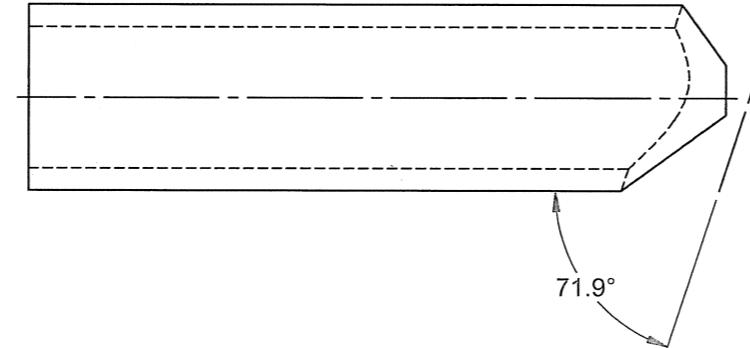
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VIEW E-E

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C250-C-5 LEFT HAND BUMPER TUBE

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT
DRAWN	KPT
CHECKED	ZF
MFG. APPR.	DP
APPROVED	
DATE 2019-10-21	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. D

SHEET 8 OF 23

SCALE
NTS

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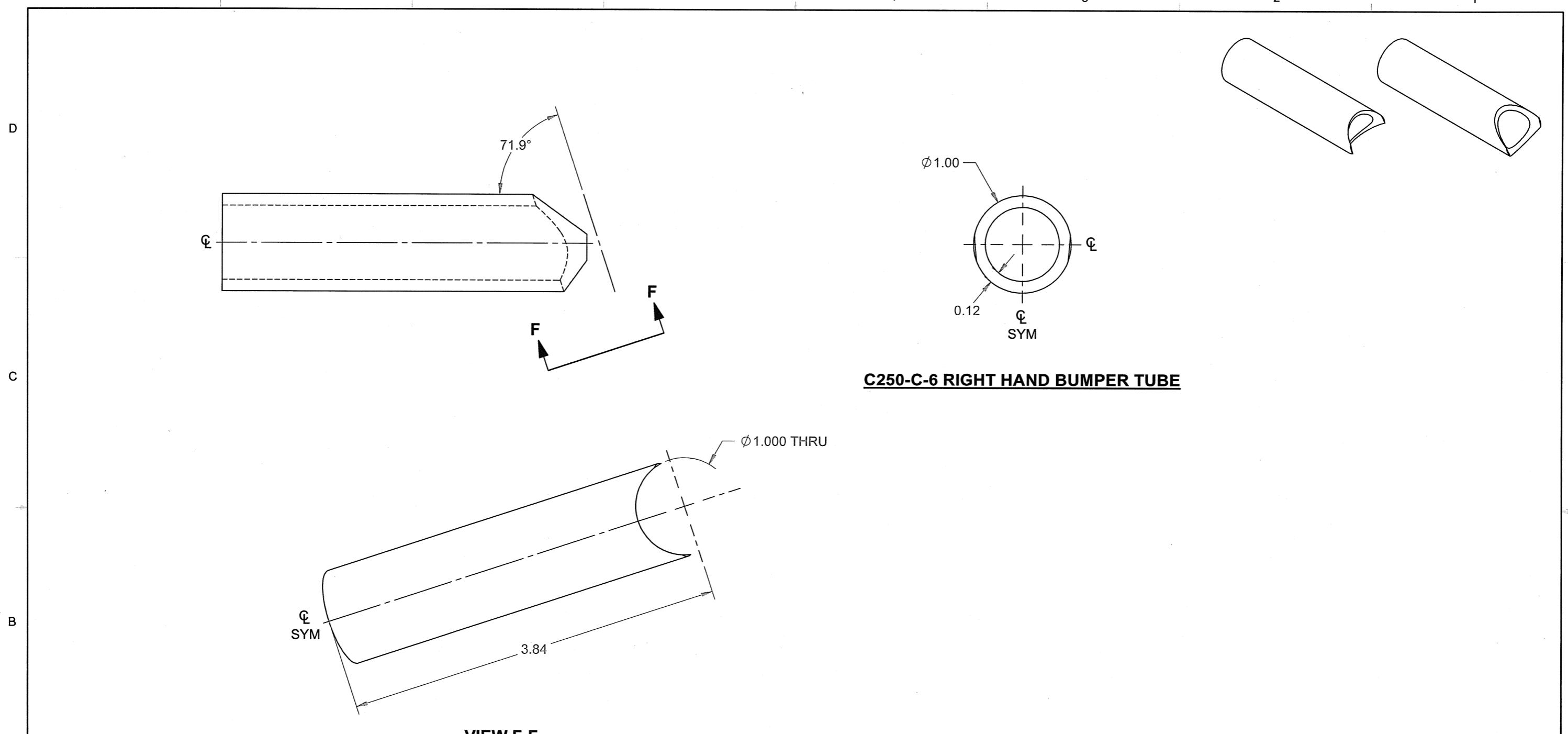
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NOTES:
 1) MATERIAL: A513 TYPE 5 DOM TUBING
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 $X.XX = +/- 0.01" / +/- 0.5°$
 $X.XXX = +/- 0.005" / +/- 0.1°$
 $X.XXXX = +/- 0.0005" / +/- 0.05°$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) REMOVE ALL SHARP EDGES AND BURRS
 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 9 OF 23
APPROVED	<i>[Signature]</i>	
DATE	2019-10-21	
TOOL PART #	C250-C	
TITLE	C250 CAGE ASSEMBLY	
SCALE	NTS	

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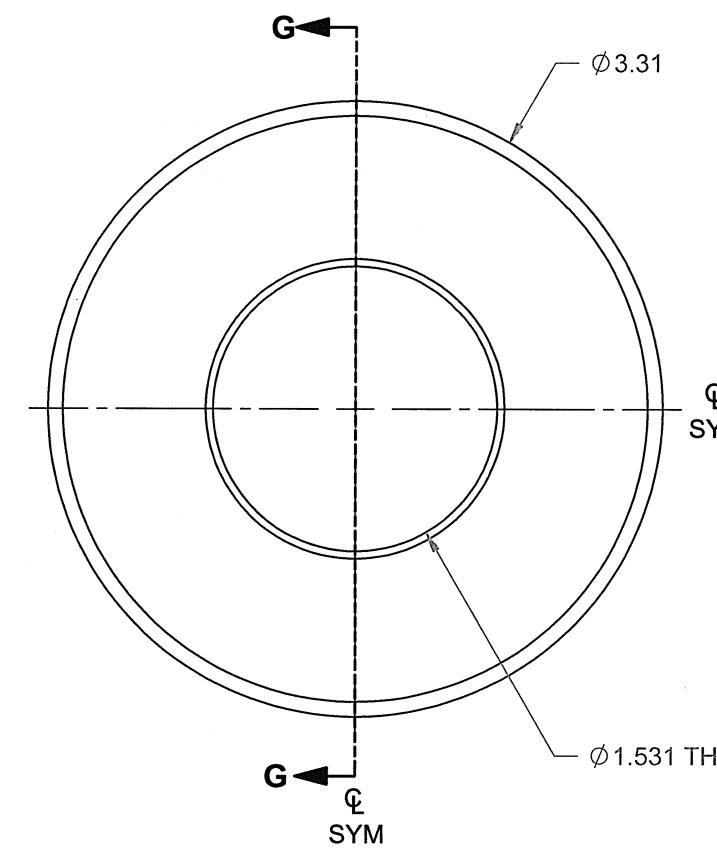
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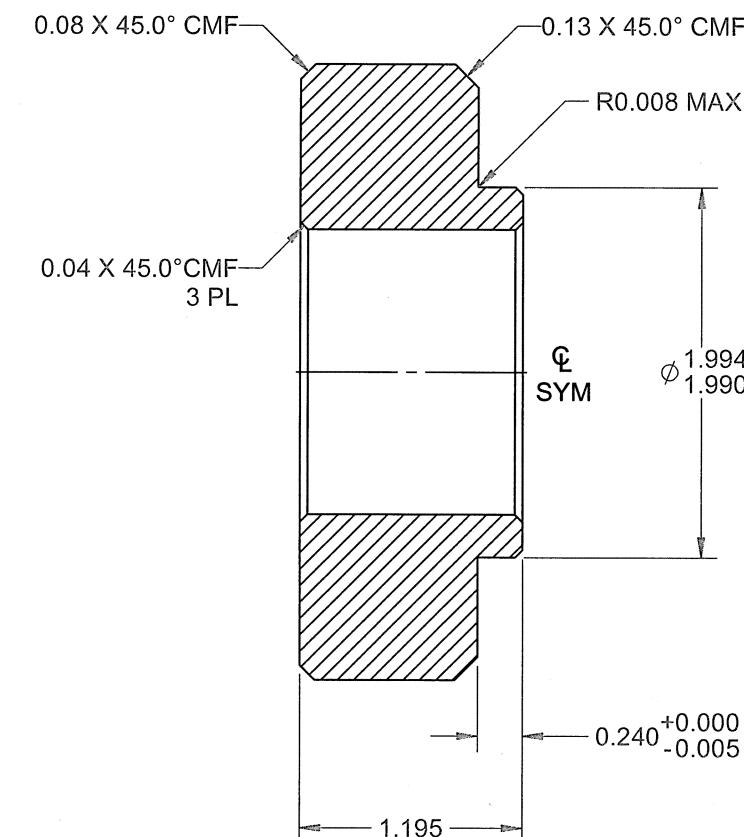
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C250-C-7 CAGE BOSS



SECTION G-G

NOTES:

- NOTES:

 - 1) MATERIAL: 1018/1020/1025 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.001"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. D	
MFG. APPR.	DP	SHEET 10 OF 23	
APPROVED		TITLE	SCALE
DATE	2019-10-21	C250 CAGE ASSEMBLY	NTS

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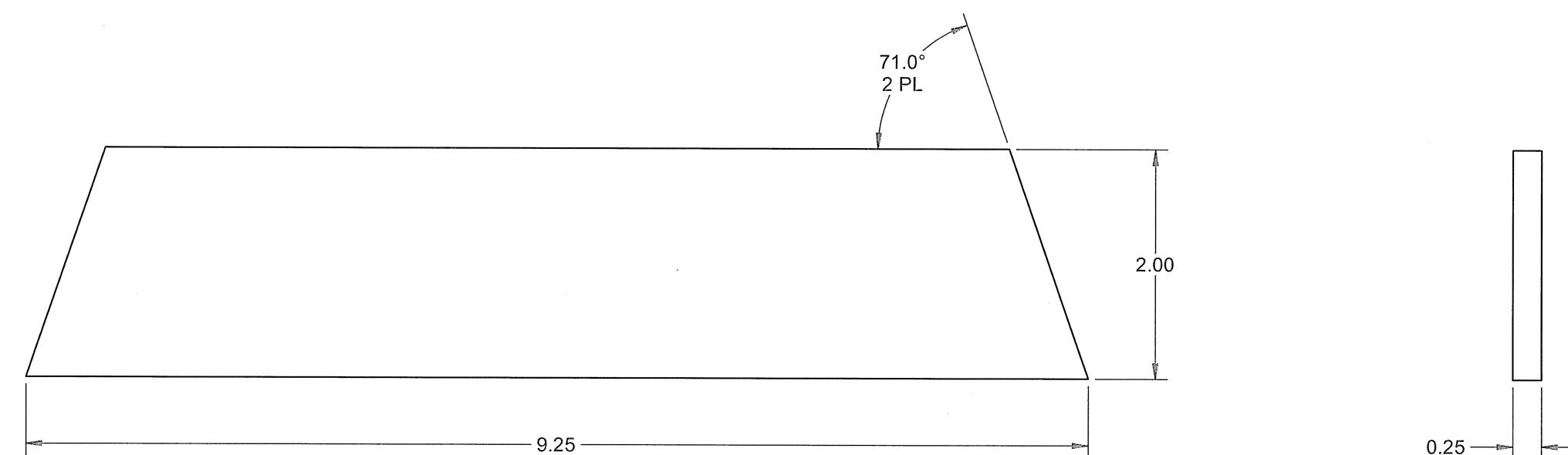
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NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

**C250-C-8 FRONT PLATE**

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	ZF	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	REV. D	SHEET 11 OF 23
APPROVED	WHP	TITLE C250-CAGE ASSEMBLY	
DATE 2019-10-21		SCALE	NTS

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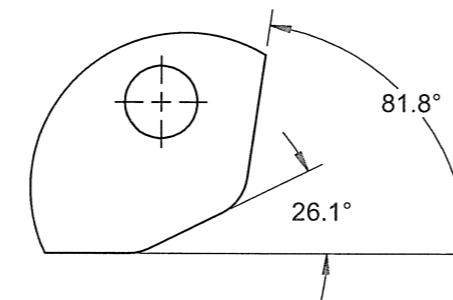
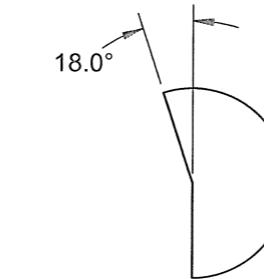
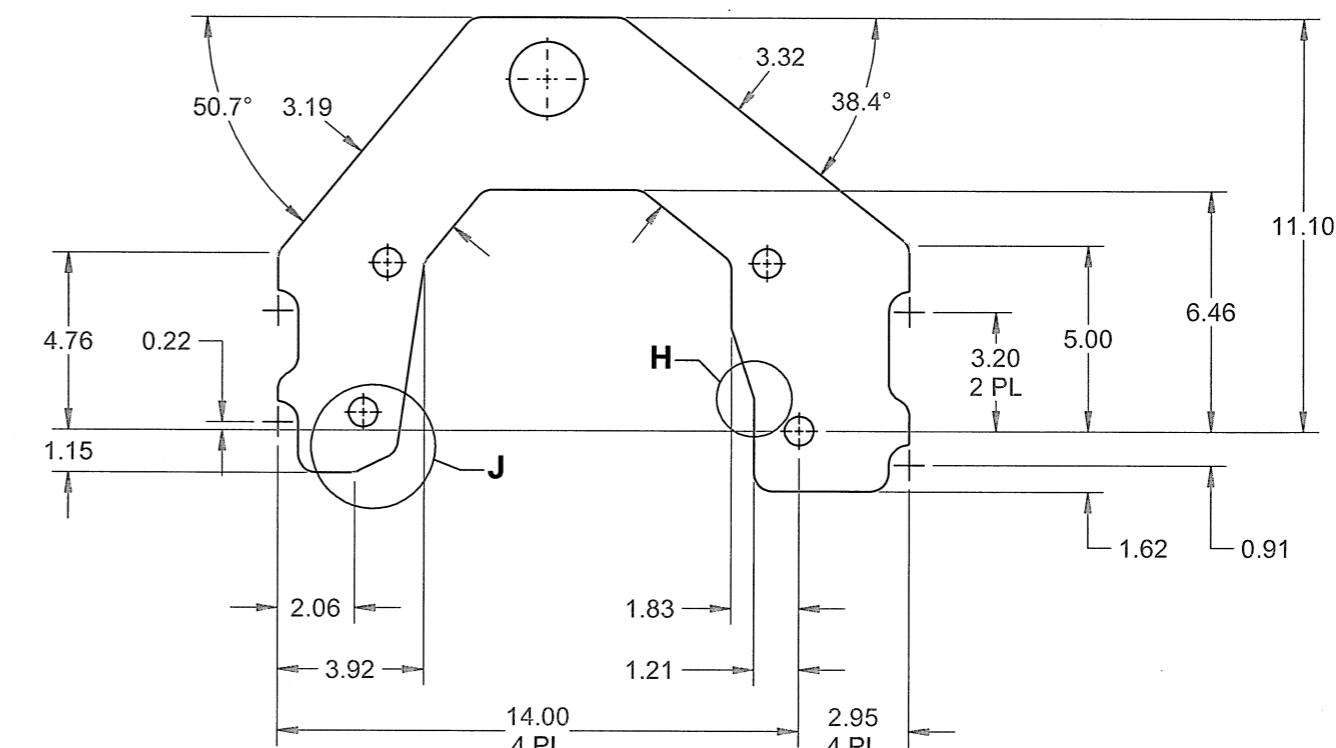
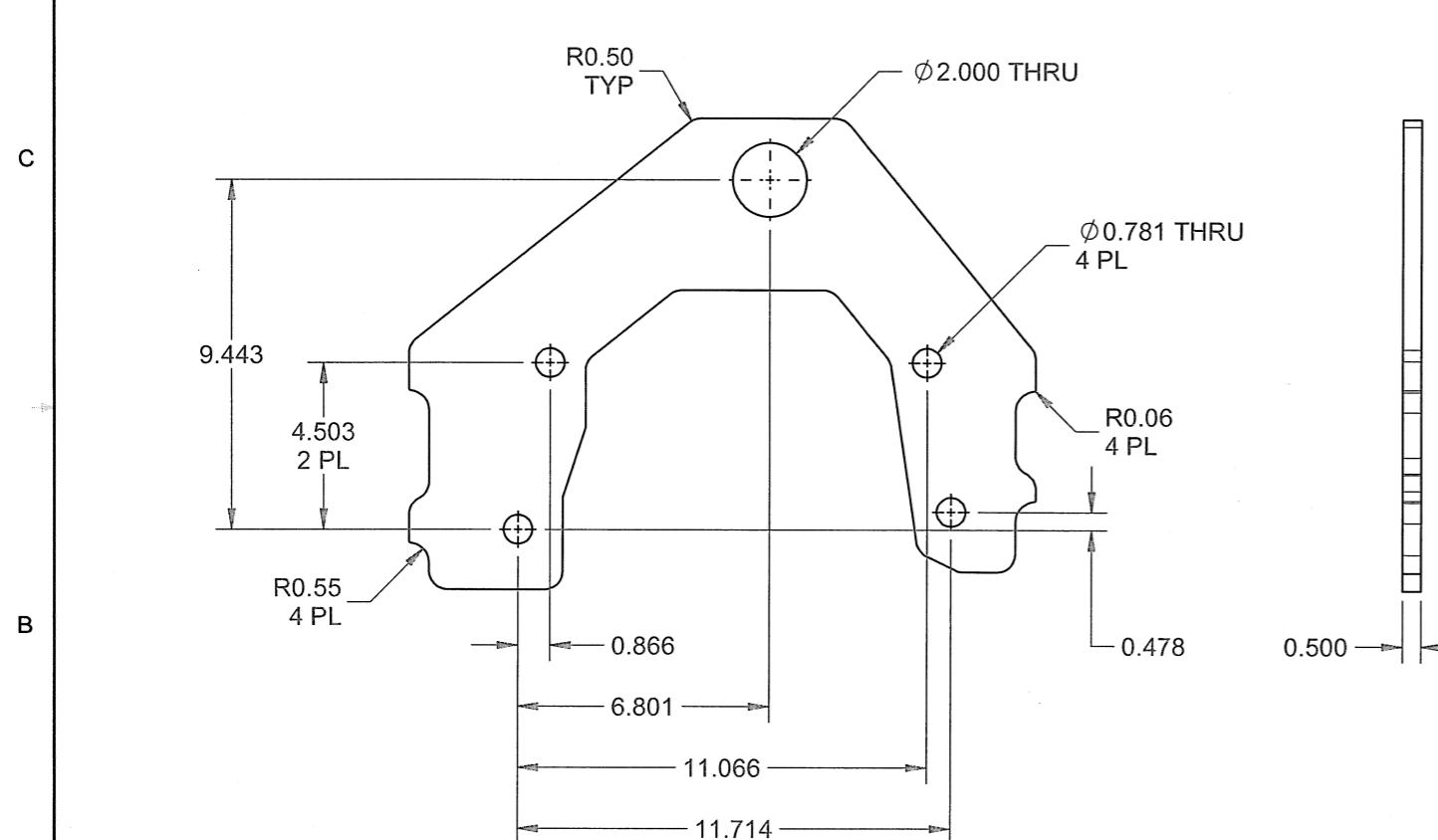
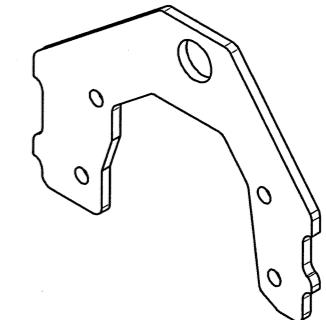
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**DETAIL J****DETAIL H****C250-C-9 LIFTING PLATE****NOTES:**

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 12 OF 23
APPROVED		SCALE NTS
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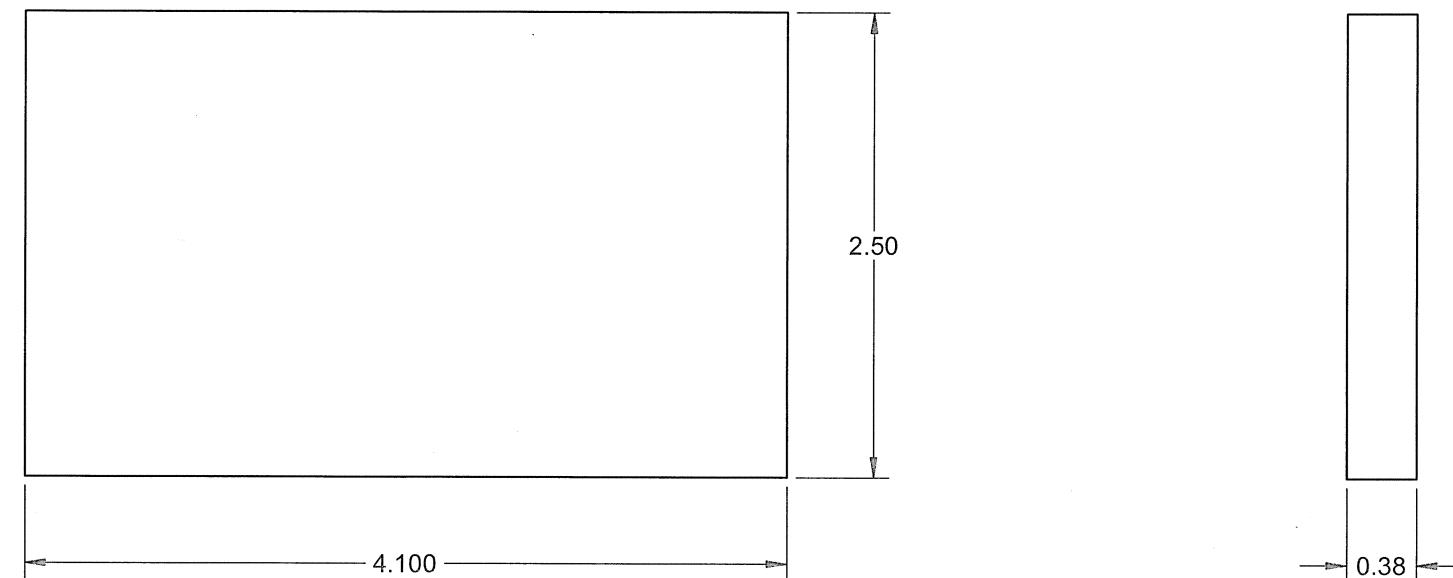
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C250-C-10 LIMITING PLATE

NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	TOOL PART #	REV. D
MFG. APPR.	DP	C250-C	SHEET 13 OF 23
APPROVED	<i>[Signature]</i>	TITLE C250 CAGE ASSEMBLY	
DATE 2019-10-21		SCALE	NTS

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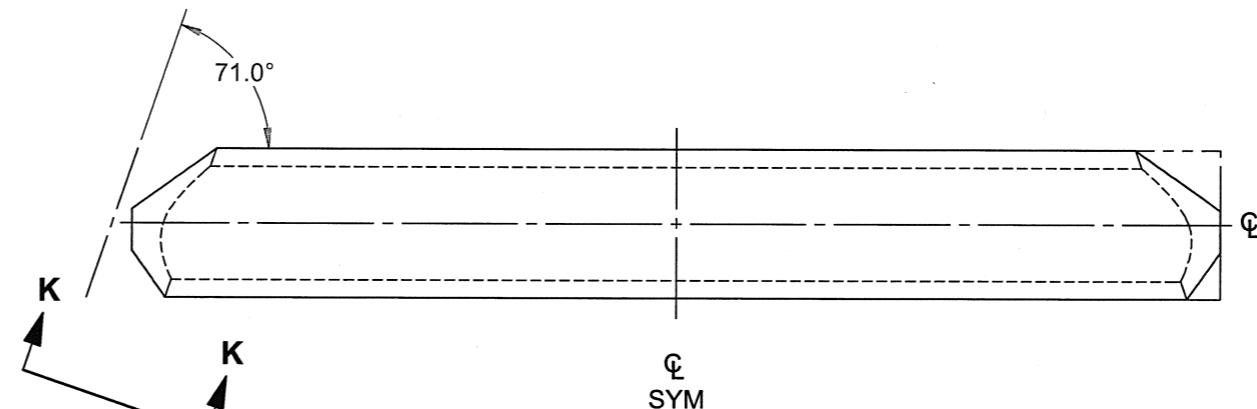
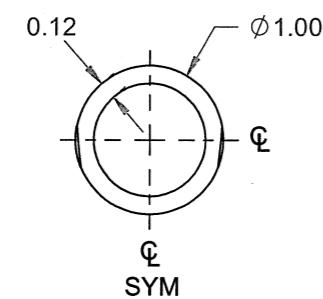
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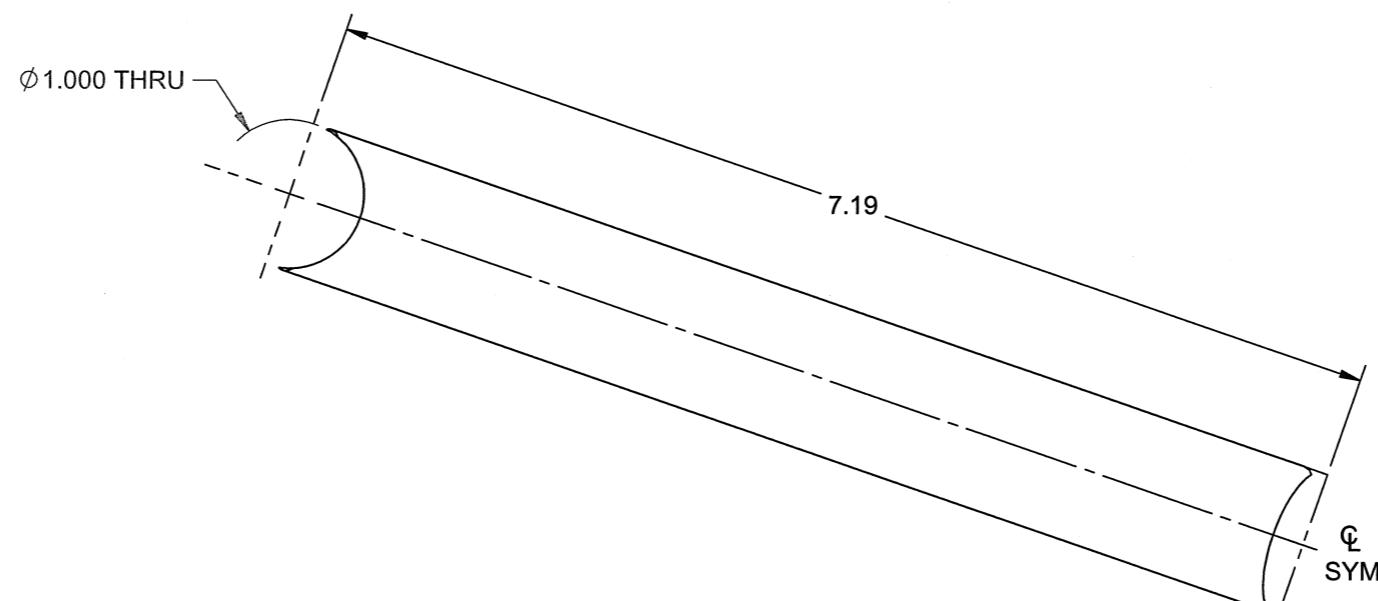
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C250-C-11 MID TUBE



VIEW K-K
2 PL

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 14 OF 23
APPROVED	WJ	SCALE NTS
TOOL PART #	C250-C	
TITLE	C250 CAGE ASSEMBLY	
DATE	2019-10-21	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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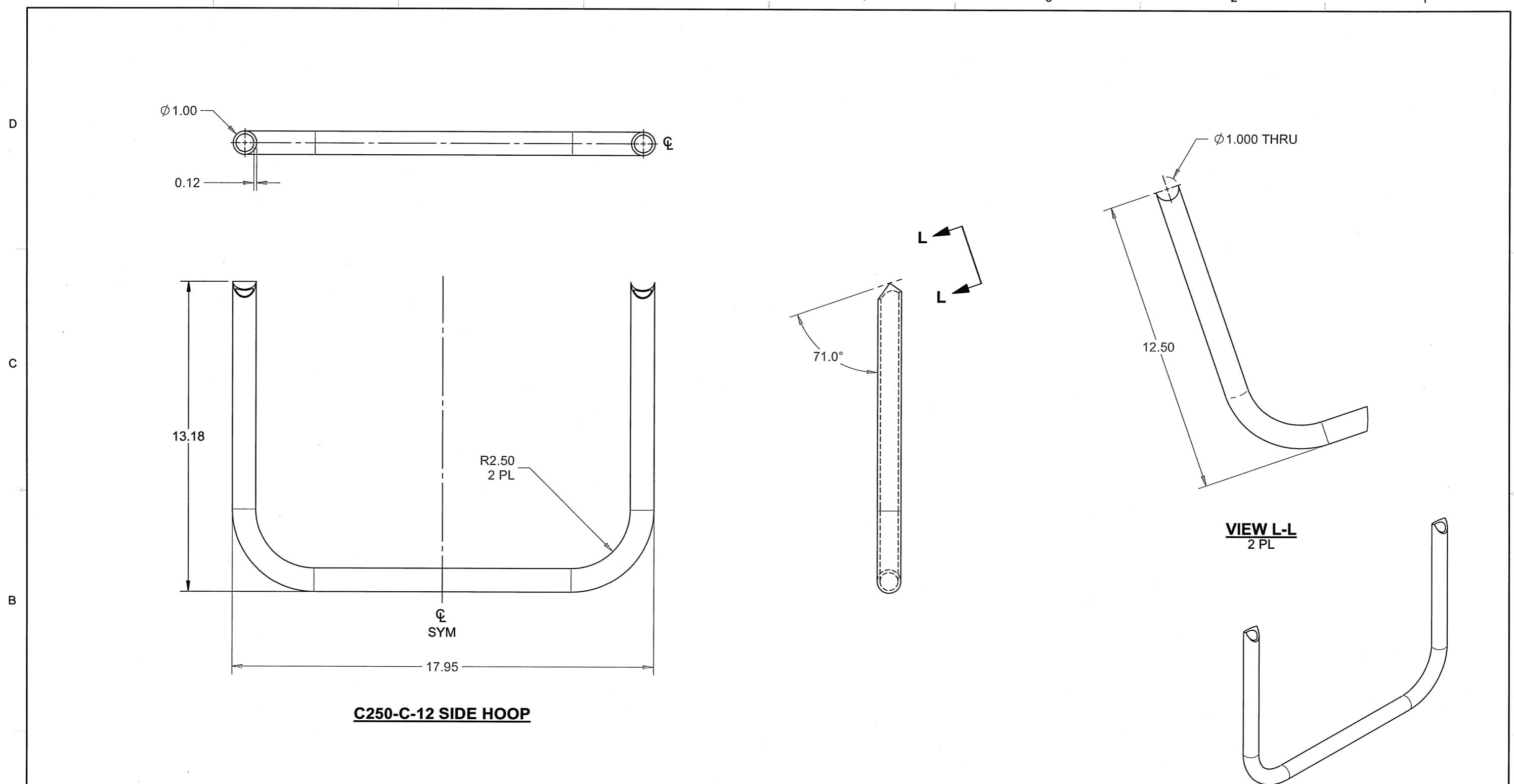
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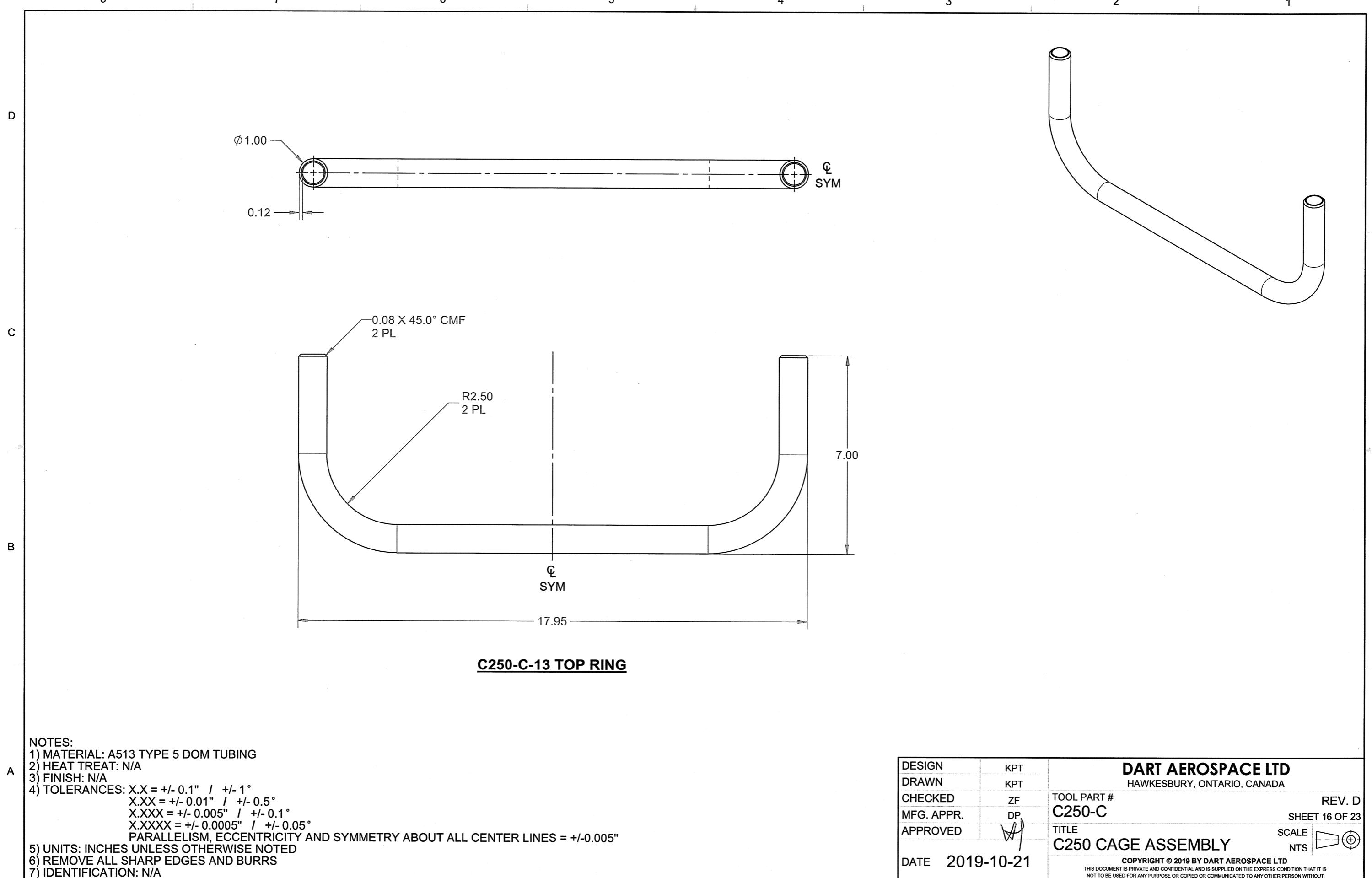
C250-C-12 SIDE HOOP

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. D	
MFG. APPR.	DP	TOOL PART #	
APPROVED	WHP	C250-C	
TITLE		SHEET 15 OF 23	
C250 CAGE ASSEMBLY		SCALE	NTS
DATE 2019-10-21		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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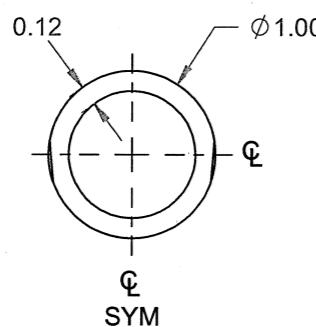
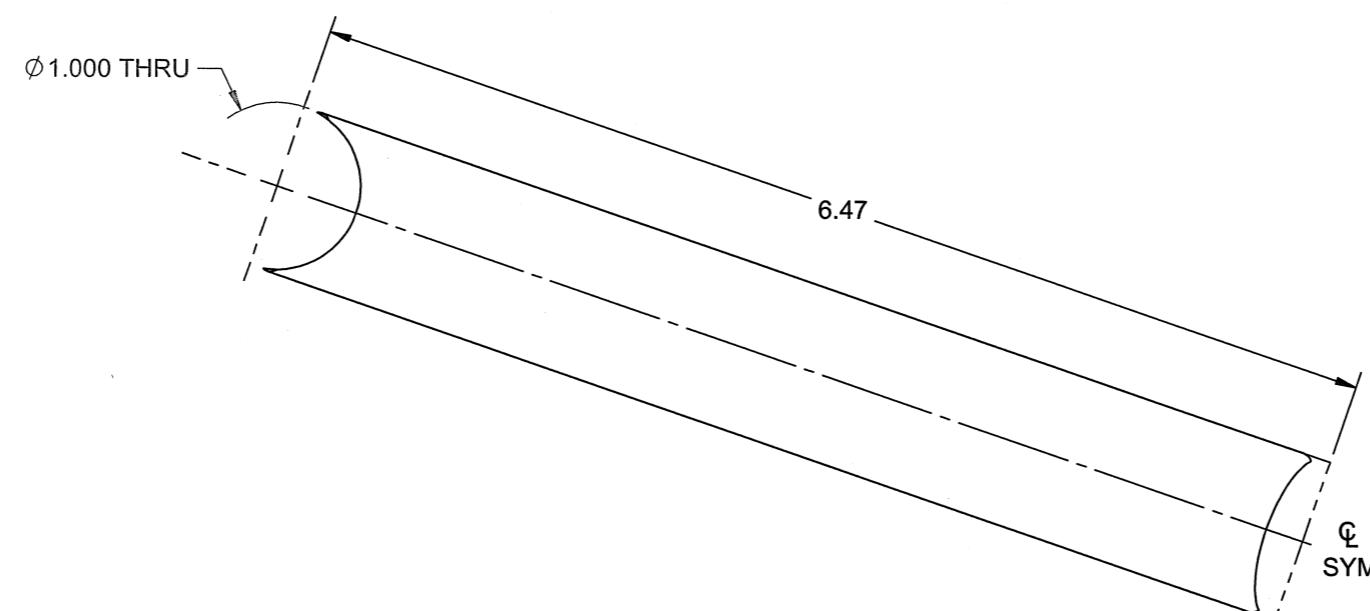
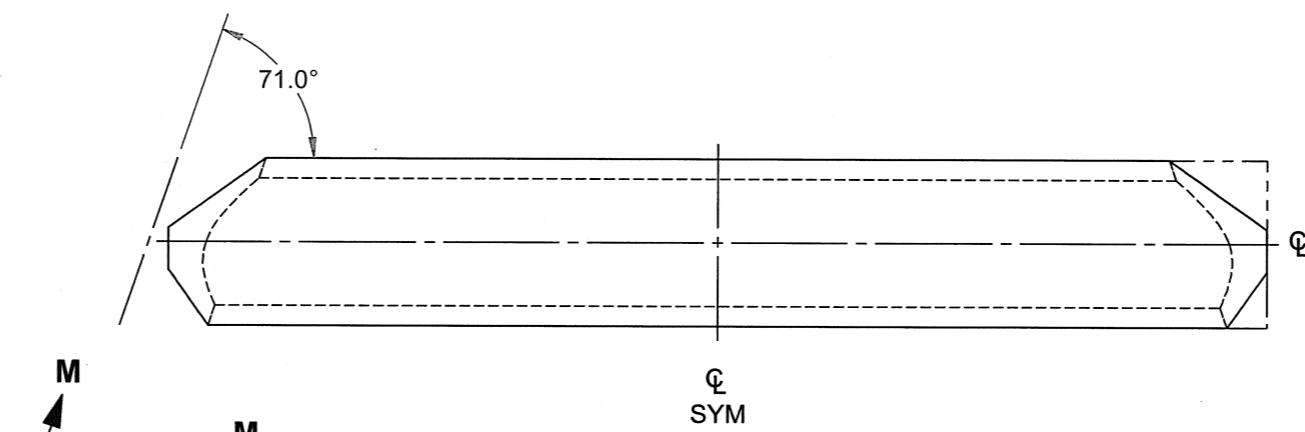
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**C250-C-14 TOP TUBE****VIEW M-M**
2 PL**NOTES:**

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 17 OF 23
APPROVED	WJ	NTS
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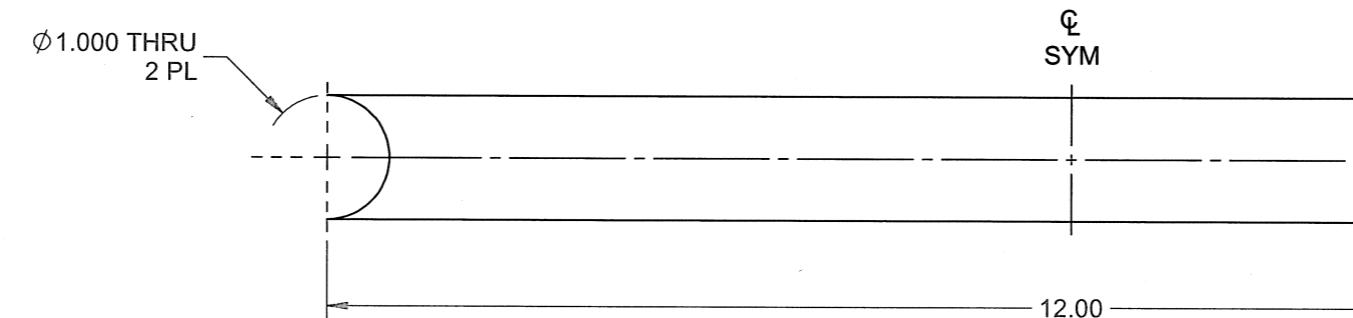
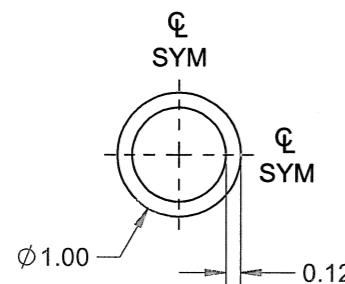
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C250-C-15 SIDE TUBE**NOTES:**

1) MATERIAL: A513 TYPE 5 DOM TUBING

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 18 OF 23
APPROVED	<i>[Signature]</i>	SCALE NTS
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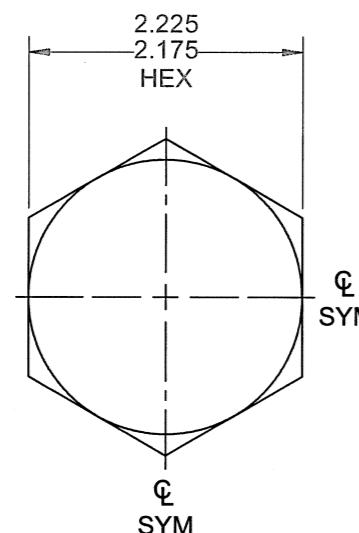
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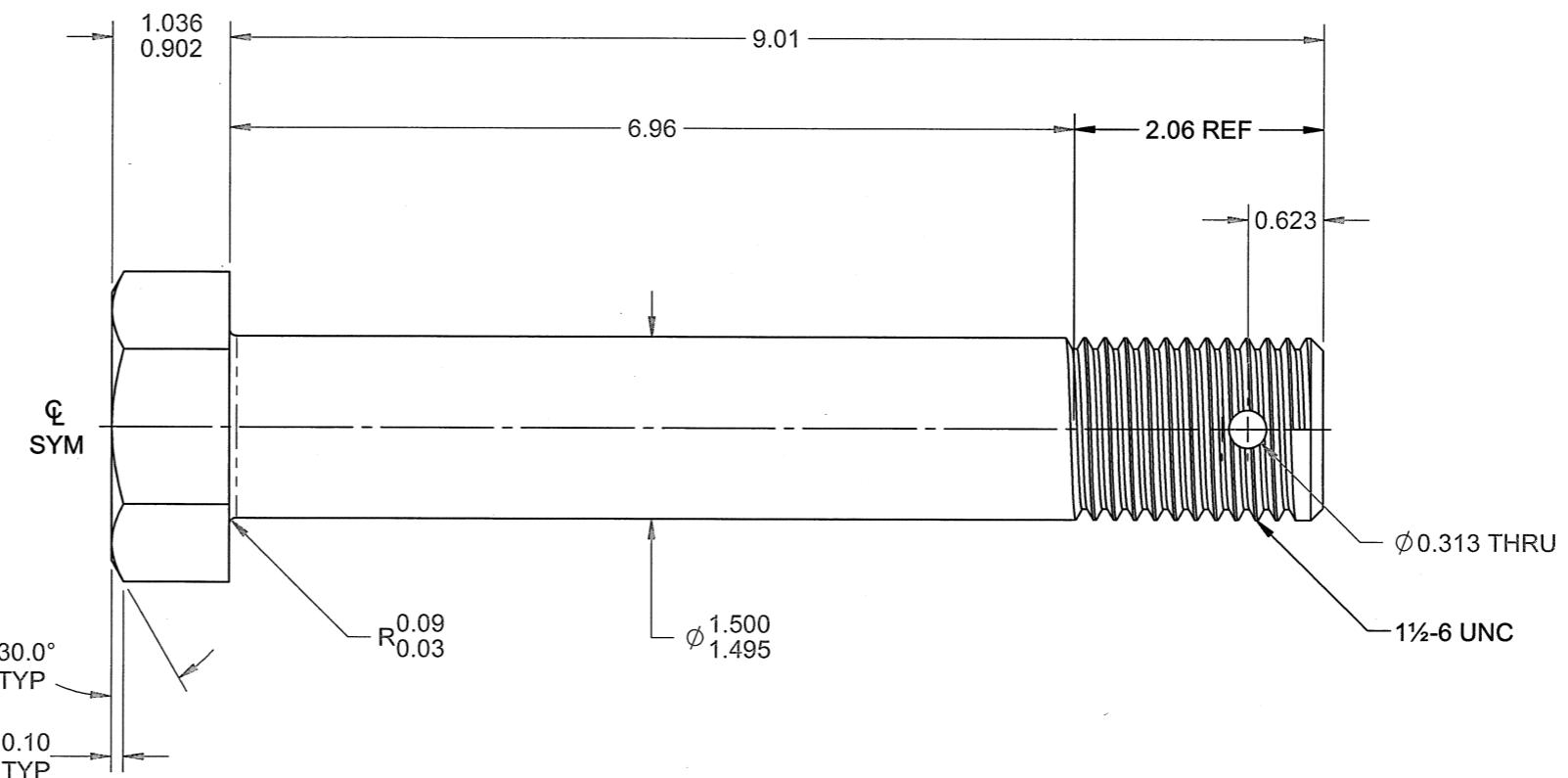
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C250-C-16 LIFTING BOLT

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NOTES:

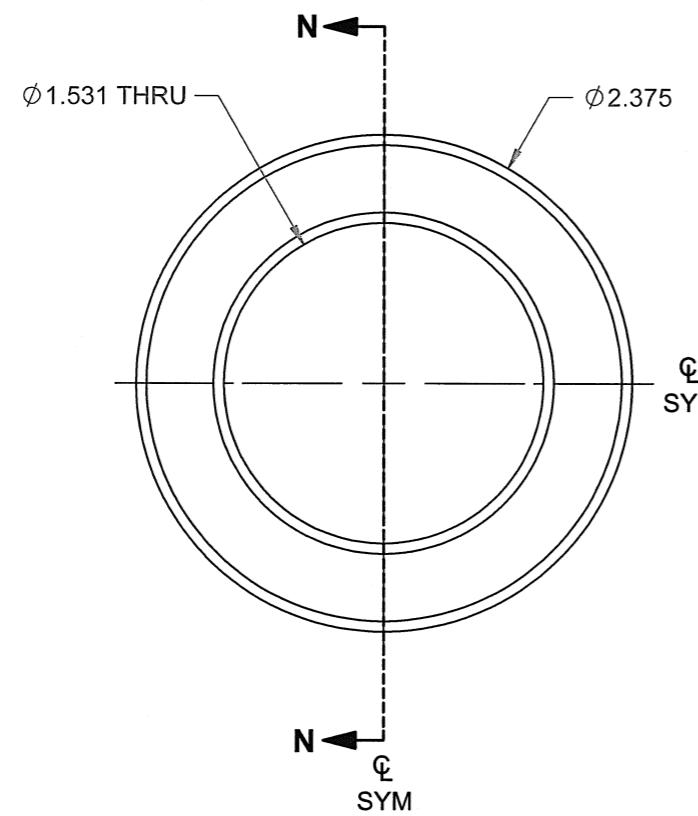
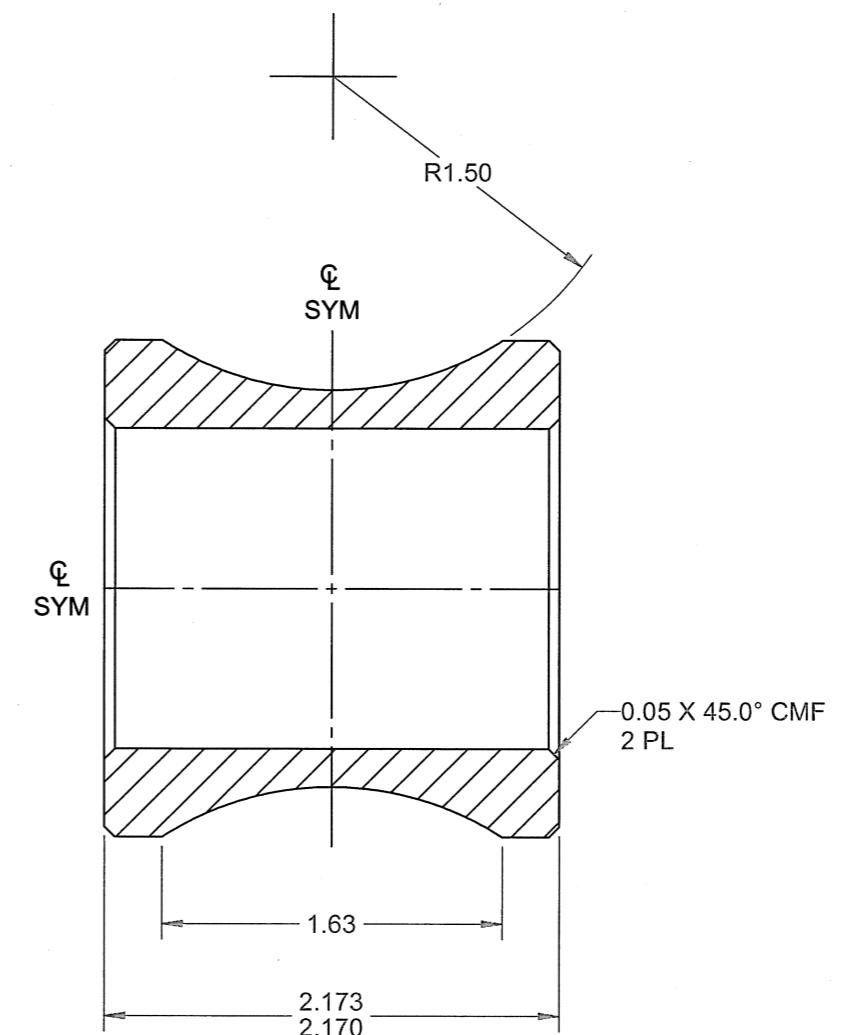
- 1) MATERIAL: SEE NOTE 8
- 2) HEAT TREAT: SEE NOTE 8
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) LIFTING BOLT MUST CONFORM TO ASTM A354 (GRADE BD)

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 19 OF 23
APPROVED	<i>[Signature]</i>	SCALE NTS
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**C250-C-17 LIFTING BUSHING****SECTION N-N****NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: NICKEL PLATE PER MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A CLASS 2 GRADE E
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	TOOL PART #	C250-C
MFG. APPR.	DP	REV. D	SHEET 20 OF 23
APPROVED	<i>[Signature]</i>	SCALE	NTS
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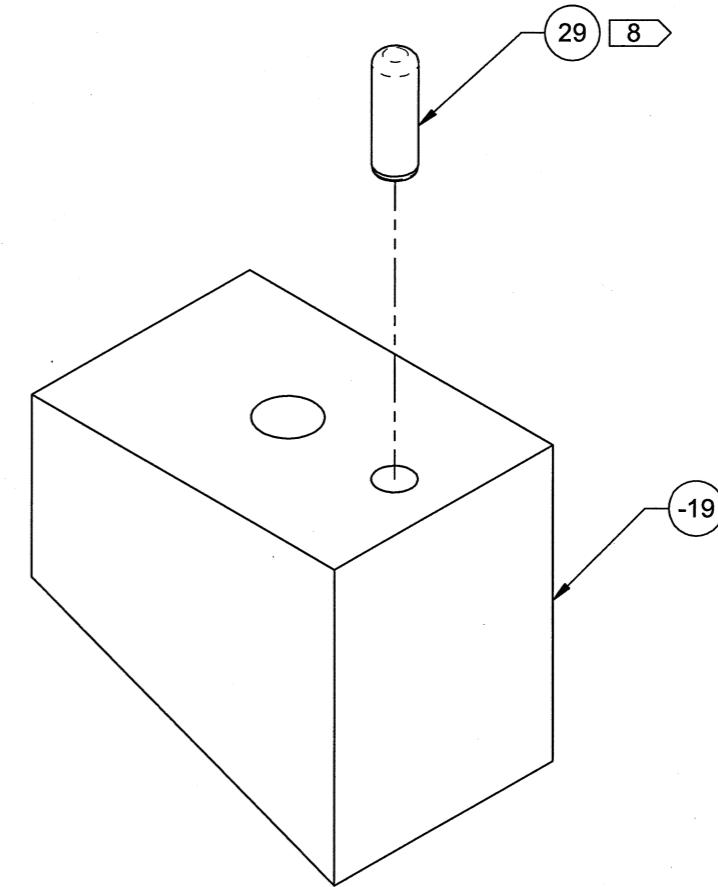
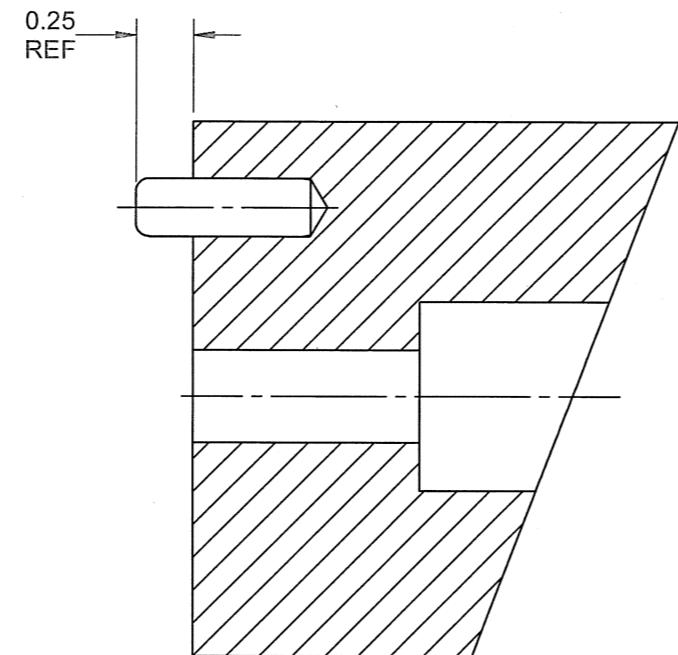
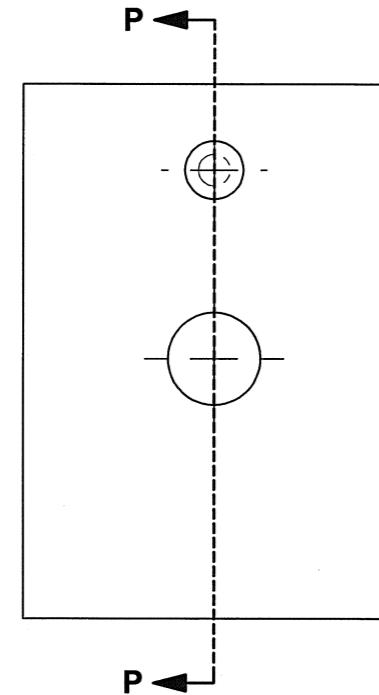
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ITEM #	QTY	PART #	PART TITLE
-19	1	C250-C-19	BUMPER
29	1	MS16555-646	SS DOWEL PIN 1/4" DIA. X 3/4" LG.

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**C250-C-18 BUMPER ASSEMBLY**

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 29 WITH ITEM -19, AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. D	
MFG. APPR.	DP	SHEET 21 OF 23	
APPROVED	<i>[Signature]</i>	DATE 2019-10-21	
TOOL PART #		C250-C	
TITLE		C250 CAGE ASSEMBLY	
SCALE NTS			

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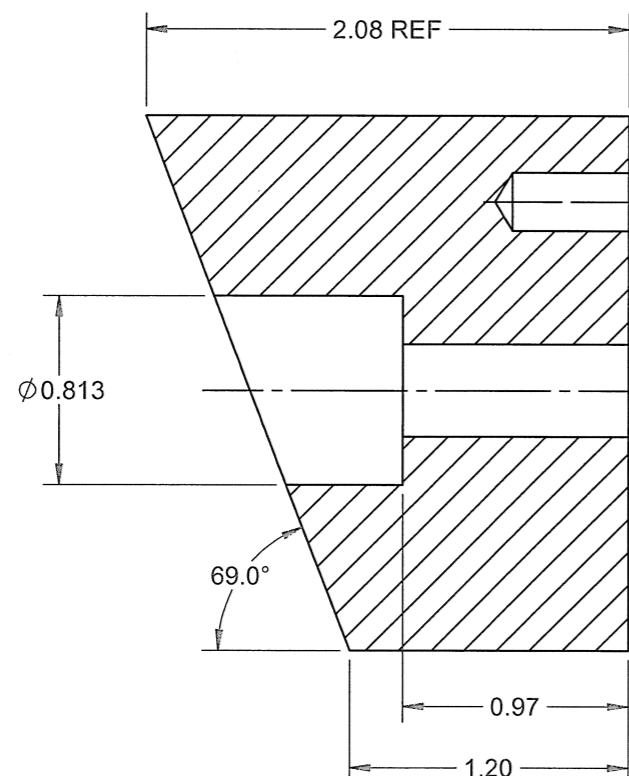
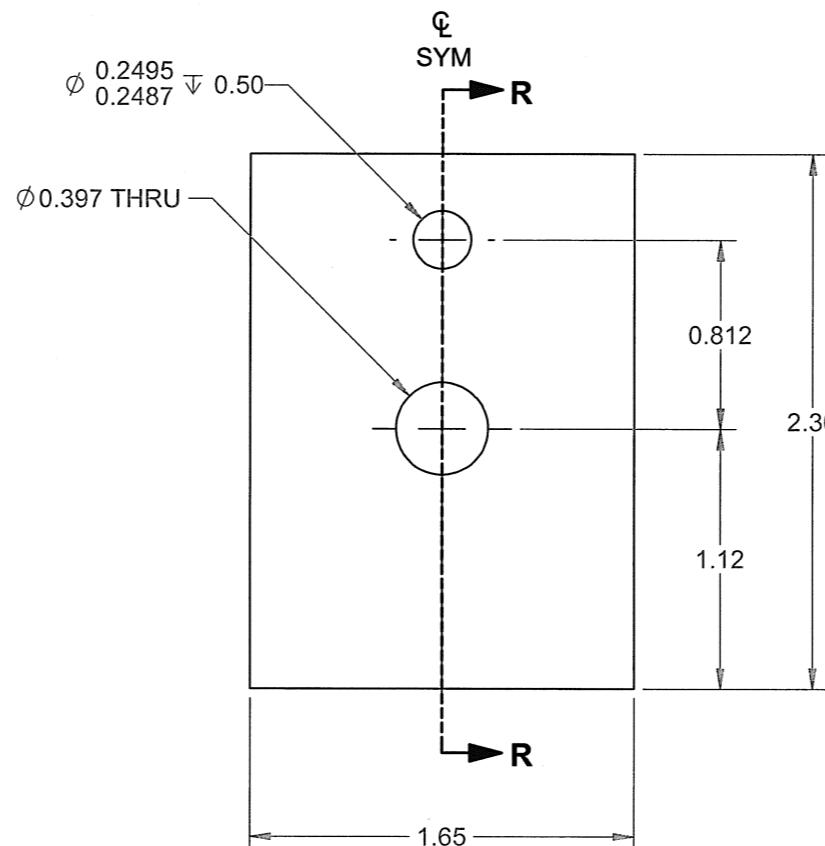
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SECTION R-RC250-C-19 BUMPER

NOTES:

- 1) MATERIAL: UHMW
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. D
MFG. APPR.	DP	SHEET 22 OF 23
APPROVED	VJ	SCALE
		NTS
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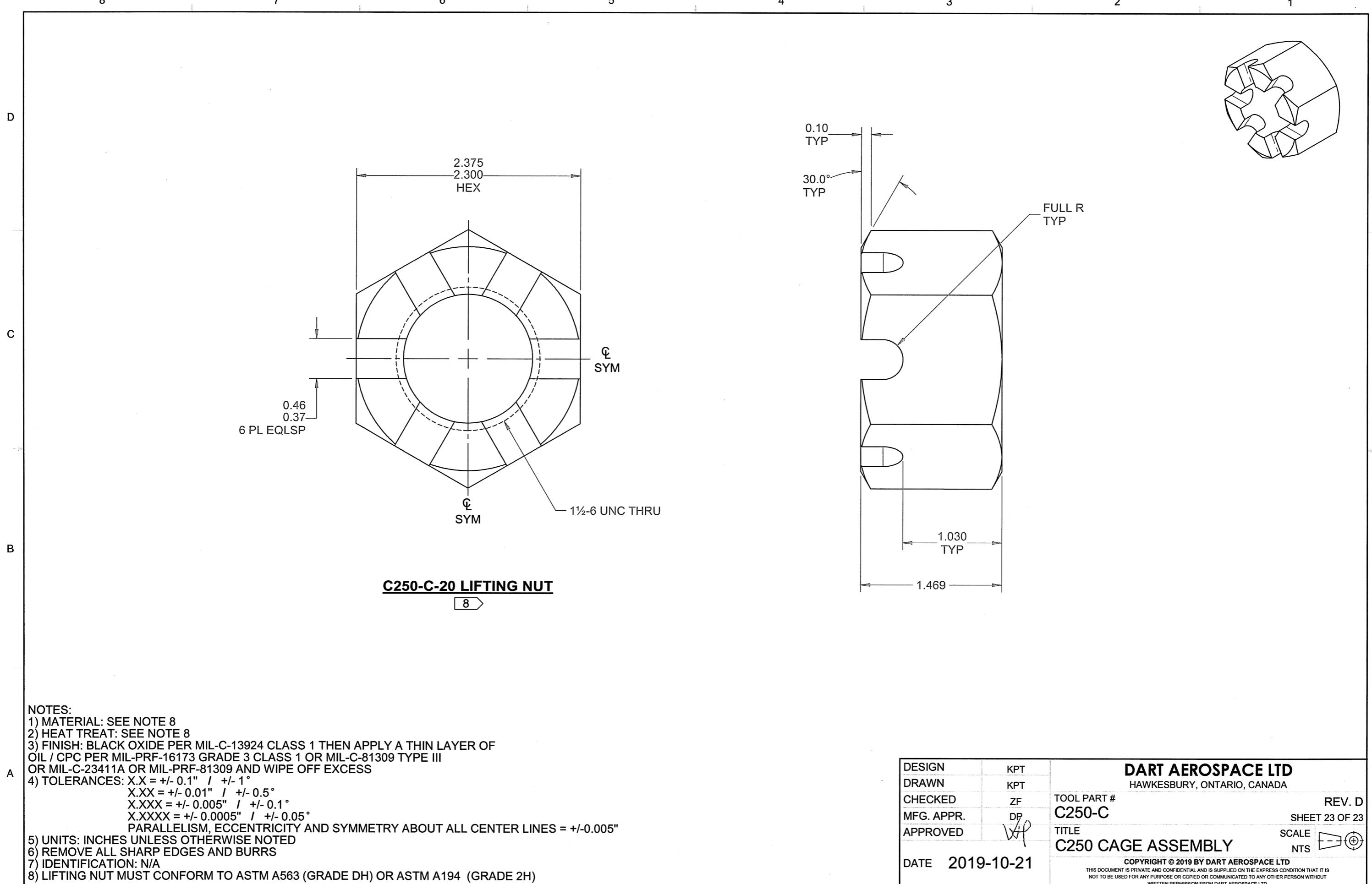
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